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D5068-041
Job Sheet 203189



Part No: D5068-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, LH/RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Due Date: 12/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5068 REV.A IPP REV:A 17.08.30 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Basket - 1	1 pcs	12/12/19		0.00	20.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		CC
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	QC 9	1 pcs	12/12/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		DAS
							QC 9 - 50		43
							QC 9 - 9		9-89
130	QC 5	1 pcs	12/12/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		DAS
							QC 5 - 49		43
							QC 5 - 51		9-89
							QC 5 - 58		



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Container No: S240519



Part: D5068 - 041

Job No: 203189

Serial No/Batch: S240519

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/18/19

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
140	Handfinish - 2-1 Pressure-B4B	1 pcs	12/12/19	0.00	0.33	Handfinish - 2 - 1 - B4B	BE 19-12-20
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
150	Powdercoat - 2 White Gl(S)-B4B	1 pcs	12/12/19	0.00	0.50	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BR 19-12-20
						Powdercoat - 4 - B4B	
160	QC 3	1 pcs	12/12/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	HL 19-12-20
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
170	Handfinish - 4-1-Assembly-B4B	1 pcs	12/12/19	0.00	0.25	Handfinish - 4 - 1 - B4B	HL 19-12-20
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	

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DAS
15
9-89

180 QC 5	1 pcs	12/12/19	0.00 0.00	Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
190 Packaging 3-1 - Stock - B4B	1 pcs	12/12/19	0.00 0.00	QC 5 - 40	DAS DEC 20 2019 40 8-89
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	14-12-28
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	1	12/12/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	DEC 20 2019
				QC 21 - SA - 53	
Part Op 110 - (Weld per dwg A/R S.S. rod Batch: <u>6138920</u>) 1- Assemble ribs , weld as per dwg D5068 using DT9610A Descriptions: ***inspect before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D5068 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- Weld hinge (3) and Mounting brackets as per dwg D5068 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg 120 - (QC9- Inspect visual per QSI004- Fusion Welds) 130 - (QC5- Inspect part completeness to step on W/O) 140 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) 150 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat 2-Mask this area prior to finish section A-A, B-B 3-1ST COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 2nd coat if necessary _____ 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Assemble as per dwg) ASSEMBLE BLANKING PLATE AND BUMPER AS PER DWG 180 - (QC5- Inspect part completeness to step on W/O) 190 - (Identify as per dwg & Stock Location: _____) 200 - (QC21- Final Inspection - Work Order Release)					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	110-Large Fab - Basket - 1	5014321
D3913-1	Rib	1 pcs (1 ea)	110-Large Fab - Basket - 1	5220643
D3913-15	Wide Handle Plate	1 pcs (1 ea)	110-Large Fab - Basket - 1	5211077
D3913-3	Rib	1 pcs (1 ea)	110-Large Fab - Basket - 1	5224671
D3913-9	Hinge Rib	1 pcs (1 ea)	110-Large Fab - Basket - 1	5223713
D3916-041	Rib Assembly	2 pcs (2 ea)	110-Large Fab - Basket - 1	5233038
D3916-5	Light Rib	2 pcs (2 ea)	110-Large Fab - Basket - 1	5234760
D4016-1	Hinge Half, Base	3 pcs (3 ea)	110-Large Fab - Basket - 1	5231789
D4017-7	Rib	3 pcs (3 ea)	110-Large Fab - Basket - 1	5233314
D4020-11	End Mesh, Basket	2 pcs (2 ea)	110-Large Fab - Basket - 1	5234922
D4021-1	Handle Plate	3 pcs (3 ea)	110-Large Fab - Basket - 1	5211134
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	110-Large Fab - Basket - 1	5230607
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	110-Large Fab - Basket - 1	5229360
D4672-1	Blanking Plate	2 pcs (2 ea)	110-Large Fab - Basket - 1	5230536
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	110-Large Fab - Basket - 1	5218454
D4785-117	Rib Assembly	2 pcs (2 ea)	110-Large Fab - Basket - 1	5233369
D5068-1	Rib	2 pcs (2 ea)	110-Large Fab - Basket - 1	5034314
D5068-3	Rib	2 pcs (2 ea)	110-Large Fab - Basket - 1	5182160
D5068-5	Rib	1 pcs (1 ea)	110-Large Fab - Basket - 1	5141698
AN3-10A	BOLT	6 Ea (6 ea)	170-Handfinish - 4-1-Assembly-B4B	5220768
D2931	Bumper	2 pcs (2 ea)	170-Handfinish - 4-1-Assembly-B4B	506435
D4021-5	Blanking Plate	2 pcs (2 ea)	170-Handfinish - 4-1-Assembly-B4B	5220799
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	170-Handfinish - 4-1-Assembly-B4B	5196541
MS21042L3	Nut	6 Ea (6 ea)	170-Handfinish - 4-1-Assembly-B4B	5211532
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	170-Handfinish - 4-1-Assembly-B4B	5216387
NAS1149DN832J	Washer	2 Ea (2 ea)	170-Handfinish - 4-1-Assembly-B4B	5034411

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Basket - 1	D2581	2	67	0
	D3913-1	1	8	0
	D3913-15	1	32	0
	D3913-3	1	8	0
	D3913-9	1	7	0
	D3916-041	2	2	0
	D3916-5	2	6	0
	D4016-1	3	8	0
	D4017-7	3	22	0
	D4020-11	2	8	0
	D4021-1	3	30	0
	D4034-041	1	5	0
	D4034-043	1	8	0
	D4672-1	2	9	0
	D4785-117	2	0	0
	D5068-1	2	2	0
	D5068-3	2	8	0
	D5068-5	1	2	0
	M304EX0.75-16F	33	586	0
170-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	130	0
	D2931	2	611	0
	D4021-5	2	17	0
	MS20600-AD4W3	2	272	0
	MS21042L3	6	2,541	0
	NAS1149DN832J	2	494	0
	NAS1149F0332P	12	4,882	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ ☐				Cross tube ☐ ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ ☐				Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ ☐				Engineering ☐ ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐ ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)													
Description Work Order Deviation				Disposition															
Root Cause Operator ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐				FAULT CATEGORY															
				Pressure/Forced ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐				Contamination ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐				Power Loss/Surge ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐				Positioned Wrong ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐			
				Other/Details:															
Completed By				Lead hand / Supervisor				QC / QA Coordinator											